

Date: Tuesday, 9/25/2007 10:11:38 AM  
 User: Kim Johnston

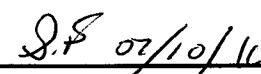
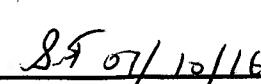
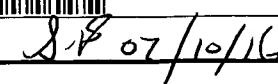
## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 34839		Part Number	: D2573		
Estimate Number	: 10533		Drawing Number	: D2573 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/25/2007 S.O. No. : N/A		Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 10/10/2007 Qty: 6 Um: Each		
Previous Run	: 34814					
Written By	:					
Checked & Approved By	:					
Comment	:		Est: 1 As Per RevE 06-01-27 JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5 
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)            7075-T7351 8.25X7.75X2.5            Make from D6101-007 billet for D2573            Ensure that grain is along 7.75" length            Batch No: B 31389  (6)</p>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
<p>Comment: HAAS CNC VERTICAL MACHINING #1            Program Batch No: B34839 Double check by:   (6)</p> <p>1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets            2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets            3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets            4-Deburr and remove all machining marks            5-Tumble to remove sharp edges.</p>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
<p>Comment: CONVENTIONAL MILLING MACHINE            Machine keyway as per dwg D2573 &amp; D2574  (6)</p>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE  (6)</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/25/2007 10:11:39 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 34839

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

JL 07/10/19

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



6X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m/

07/10/22

7.0 POWDER COATING

POWDER COATING



m/05068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 07/10/23 ⑥

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8/10/23 ⑥

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Stry33

AS 07/10/24 ⑥

10.0 QC21

FINAL INSPECTION/W/O RELEASE



⑥

Comment: FINAL INSPECTION/W/O RELEASE

AS 07/10/24 ⑥

Job Completion



NOT W/ 07/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		5 02 02					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	34839
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.442	.440	.440	.440		
B	1.745	1.755		1.752	1.750	1.750	1.750		
C	3.495	3.505		3.502	3.500	3.500	3.500		
D	1.745	1.755		1.752	1.752	1.750	1.750		
E	7.990	8.010		8.00	8.00	8.003	8.001		
F	0.490	0.510		.502	.502	.502	.500		
G	0.257	0.262	DT8683	.258	.258	.257	.257		
H	0.375	0.380	DT8684	.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		.578	.578	.568	.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.501	2.501	2.501	2.501		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.126	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.125	.125	.125	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.632	.632	.632	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.011	2.011	2.011	2.011		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: *S.P*  
Date: 07/10/16

Audited by: *J.L*  
Date: 07/10/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>RF</i>	<i>JLM</i>

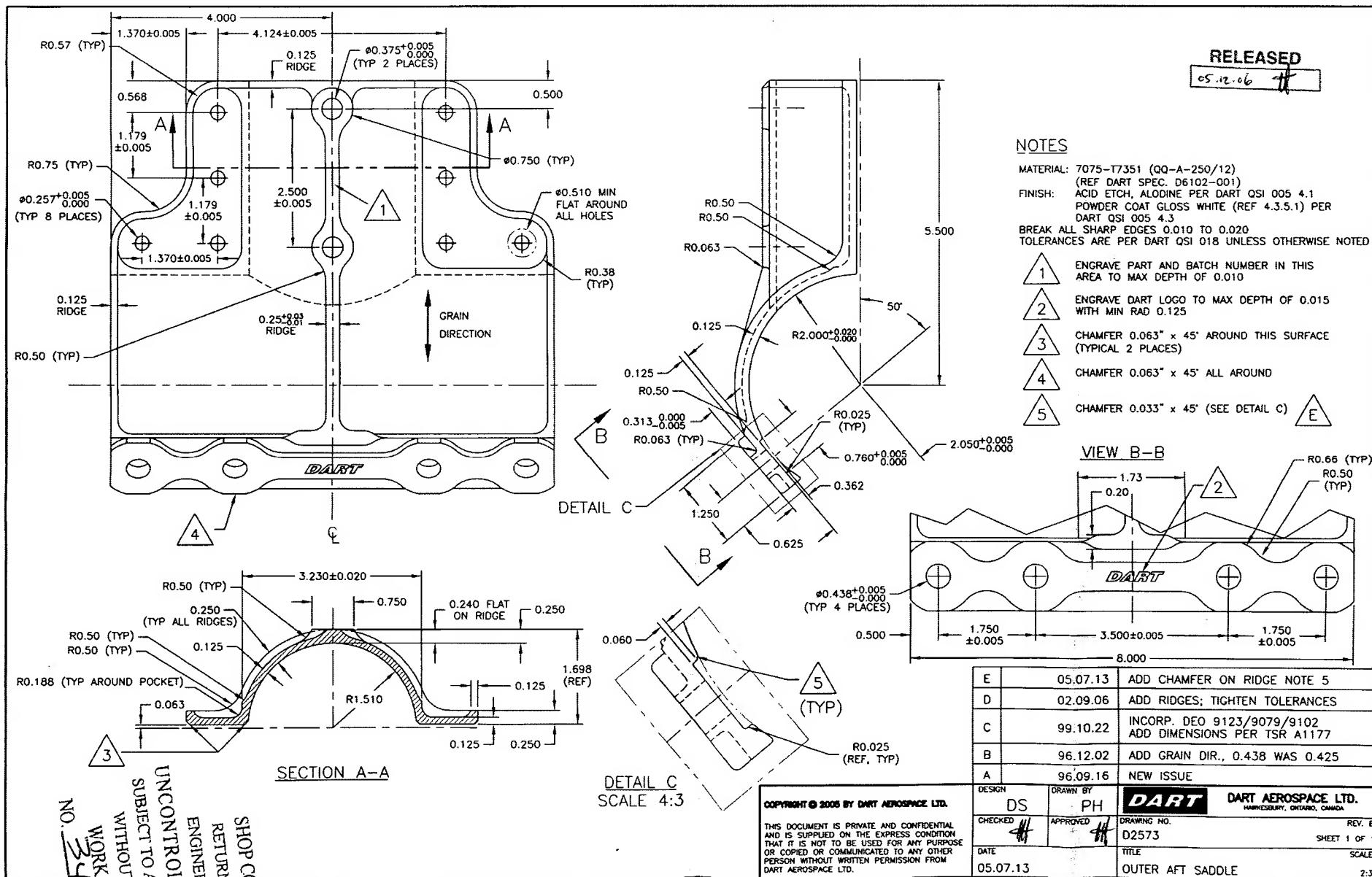
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E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.500	.500				
G	0.257	0.262	DT8683	.260	.258				
H	0.375	0.380	DT8684	.379	.378				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.178	1.177				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.178	1.177				
M	1.365	1.375		1.372	1.371				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.126	4.124				
P	0.115	0.135		.128	.128				
Q	0.115	0.135		.125	.125				
R	0.240	0.260		.256	.256				
S	0.115	0.135		.125	.125				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.229	3.237				
V	0.230	0.250		.240	.240				
W	0.115	0.135		.125	.125				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.360	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.635	.635				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.500	1.520		1.511	1.511				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.280	.280				
AH	0.240	0.260		.250	.250				
AI	2.000	2.020		2.010	2.010				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	<i>J.L.</i>	Audited by:	<i>J.L.</i>
Date:	07/10/17	Date:	07/10/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>J.L.</i>



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